

Ship 1 - 28/03

Dart Aerospace Ltd.

Date: Tuesday, 3/18/2008 3:54:24 PM
User: Kim Johnston

Process Sheet

13

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS KIT		
Job Number	38078			Part Number	D412702043B		
Estimate Number	12866			Drawing Number	IIN D412-702 REV E		
P.O. Number				Project Number	N/A		
This Issue	3/18/2008	S.O. No.		Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	11	Type	SMALL /MED FAB	Due Date	3/28/2008	Qty:	2
Previous Run	37699			Um:	Each		
Written By	<u>18/03/18</u>						
Checked & Approved By							
Comment	est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM						

Additional Product

Job Number:			
Job Number:			
Estimate Number:			
Seq. #	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	
2.0	D412702059	GROMMET KIT	
3.0	D412702101B	HARNESS ASSEMBLY	
4.0	D412702103B	HARNESS ASSEMBLY	
5.0	D412702105B	HARNESS ASSEMBLY	

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D412-702-043B CHG002

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GROMMET KIT
batch: B37355

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: B38097 10 B32790 X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: 38082

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: B38038

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:54:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D412702107B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B377091X

X
B380841X



7.0 D412702109B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: #1380851X

B377101X



8.0 D35421 BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: 34221

C



9.0 D35711 GUIDE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

GUIDE

batch: B38086

Pc 8/3/27 ②



10.0 D35713 GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GUIDE

batch: 31869

C



11.0 D3578041 DOUBLER



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

DOUBLER

batch: B37309

C



12.0 D3610041 BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: B38087

C
J
8/3/27 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0 D36181 CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

CAP

batch: 32426

14.0 AN410A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: 18057

15.0 AN444A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

bolt

batch: M104806

16.0 MS24693S274 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104219

17.0 MS24694S56 SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

batch: M104407

18.0 MS24694S58 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M11735

19.0 MS24694S60 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M11766

1/3/2008 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:54:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN960JD416 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M106277

21.0 AN960JD416L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M106785

22.0 MS21042L4 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M106825

23.0 CR3212404 Cherry Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Cherry Rivet

batch: M107008

8/3/08 (2)

24.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/3/08 (2)

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-043B CHG001

Location:

PPP Rev: B

8/3/08 50 6 2x

26.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/3/08 (2)

Job Completion



8/3/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041A	QTY -043A	QTY -045A	QTY -047A	QTY -049A	Part Number	Description
X					D412-702-041A	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043A	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045A	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047A	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049A	Dart 1-Man 3-Point Forward Facing Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101A	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-042	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103A	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-041	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105A	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-042	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107A	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-042	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109A	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-041	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COTW
RETURN TO
ENGINEERING
UNCONTROLLED COTW
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38078

QTY -041A	QTY -043A	QTY -045A	QTY -047A	QTY -049A	Part Number	Description
2		2			D412-702-111A	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-043	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113A	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-044	SHOULDER HARNESS
4*		4*			MS24693S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115A	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-042	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117A	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-041	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY
RETURN TO
ENGINEERING
LED COPY
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38078